FIG 1

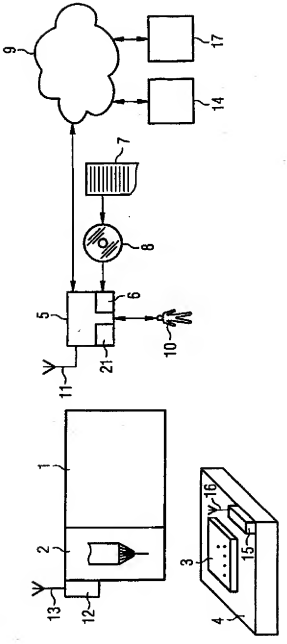


FIG 2

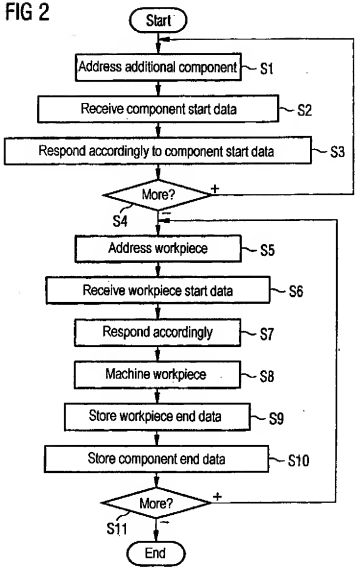

Start
Address additional component
S1
Receive component start data
S2
Respond accordingly to component start data
S3
More?
+
S4
−
Address workpiece
S5
Receive workpiece start data
S6
Respond accordingly
S7
Machine workpiece
S8
Store workpiece end data
S9
Store component end data
S10
More?
+
S11
−
End

FIG 3

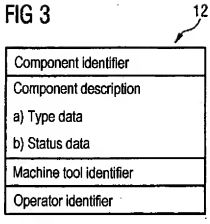

12
Component identifier
Component description
a) Type data
b) Status data
Machine tool identifier
Operator identifier

FIG 4

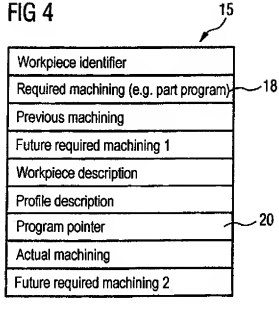
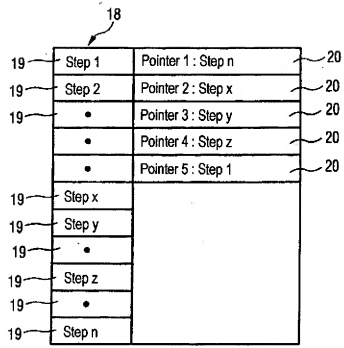

15
Workpiece identifier
Required machining (e.g. part program)
18
Previous machining
Future required machining 1
Workpiece description
Profile description
Program pointer
20
Actual machining
Future required machining 2

FIG 5


18
19
Step 1
Pointer 1 : Step n
20
19
Step 2
Pointer 2 : Step x
20
19
Pointer 3 : Step y
20
Pointer 4 : Step z
20
Pointer 5 : Step 1
20
19
Step x
19
Step y
19
19
Step z
19
19
Step n